

Method for removing nitrogen oxides from exhaust gases

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Abstract

A method for removing nitrogen oxides from exhaust gases containing oxygen and moisture, which comprises bringing the exhaust gas into contact with hydrogenated zeolite catalysts or hydrogenated zeolite catalysts impregnated with one or more kinds of metals selected from the group consisting of copper, zinc, vanadium, chromium, manganese, iron, cobalt, nickel, rhodium, palladium, platinum, and molybdenum, in the presence of organic compounds. The zeolite should be a zeolite having a silica/alumina ratio of 5 or above. The zeolite may be any one of zeolite of Y type, zeolite of L type, zeolite of offretite-erionite mixed crystal type, zeolite of ferrierite type, zeolite of mordenite type, zeolite of clinoptilolite type, and zeolite of ZSM-5 type.

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Description

BACKGROUND OF THE INVENTION

1. Field of the Invention

The present invention relates to a method of treating exhaust gases, especially those discharged from diesel engines, gasoline engines or gas turbines which contain excess oxygen and moisture as well as nitrogen oxides (abbreviated as NOx hereinafter). The method comprises bringing the exhaust gas into contact with a zeolite catalyst in the presence of organic compounds, thereby converting NOx in the exhaust gas into harmless nitrogen gas.

2. Description of the Prior Art

There are several practical methods for removing NOx from exhaust gases. For example, the selective reduction method is applied to exhaust gases from boilers which employs the V₂O₅-TiO₂ catalyst and ammonia gas as the reducing agent. The method applied to exhaust gases from gasoline engines consists of controlling the air-fuel ratio (hence the oxygen concentration) and removing NOx, carbon monoxide, and hydrocarbons all at once by the use of the ternary catalyst. (See Funahiki and Yamada, "Catalysts for Automotive Exhaust Gas", Preprints of the Meeting for Theoretical Fundamental Study of Practical Catalysts, Catalysis Society of Japan, p. 15-20, 1989.) The former method has an advantage of being effective for removing NOx from exhaust gases containing excess oxygen, but it has also a disadvantage of requiring ammonia gas as the reducing agent. Therefore, it is useful for special applications but not for general uses. Especially, it can hardly be applied to vehicles carrying a diesel engine of compression ignition type and to small- or medium-sized stationary boilers. The latter method using the ternary catalyst is not effective for exhaust gases containing excess oxygen and hence it is not of practical use for exhaust gases from diesel engines.

SUMMARY OF THE INVENTION

It is an object of the present invention to provide a method for removing NOx effectively which can be applied to exhaust gases containing excess oxygen without the need of using ammonia.

This object is fulfilled by using as the catalyst hydrogenized zeolites as such or hydrogenated zeolite catalysts impregnated with one or more kinds of metals selected from the group consisting of copper, zinc, vanadium, chromium, manganese, iron, cobalt, nickel, rhodium, palladium, platinum, and molybdenum, in the presence of organic compounds. Thus, according to the present invention, it is possible to selectively remove nitrogen oxides from exhaust gases containing excess oxygen.

DETAILED DESCRIPTION OF THE INVENTION

According to the present invention, hydrogenated zeolites are used as a catalyst or catalyst support. The hydrogenation of the zeolite is carried out either by a direct method or an indirect method. The former method involves the steps of washing the zeolite with mineral acids repeatedly and exchanging cations in the zeolite with hydrogen ions. The latter method involves the steps of washing the zeolite with ammonium ion-containing water repeatedly, replacing cations in the zeolite with ammonium ions, and calcining the zeolite thereby volatilizing ammonia. Both methods can be used for the present invention.

One of the most important features of the present invention is to use hydrogenated zeolites. Zeolite without hydrogenation removes NOx very little as demonstrated in Example 1 and Comparative Example 1 which follow. There are no restrictions as to the species of the zeolites to be used in the present invention; it may be either a synthetic one or a naturally occurring one, so long as it is hydrogenated.

It is well known that the acid resistance of a zeolite depends on the silica/alumina ratio which indicates the chemical composition of the zeolite, and that the smaller the silica/alumina ratio, the lower the acid resistance. It is also known that hydrogenated zeolites are hydrophobic and have the properties of solid acids, the strength of which depend also on the silica/alumina ratio. (See Course of Catalysts, vol. 10, compiled by the Catalysis Society of Japan, published by Kodansha, 1986.) These facts may suggest that the activity of catalysts supported on zeolites will greatly vary depending on the silica/alumina ratio. The present inventors found from many experiments on a variety of zeolites that desired catalysts in the present invention are obtained by hydrogenating zeolites having a silica/alumina ratio higher than about 5, as demonstrated in Examples 1 and 2 that follow. In addition, more active catalysts are obtained by hydrogenating zeolites having a silica/alumina ratio higher than about 10, as demonstrated in the same examples.

According to the present invention, the hydrogenated zeolite catalyst can be prepared by hydrogenating a synthetic zeolite (such as zeolite of Y type, zeolite of L type, zeolite of offretite-erionite mixed crystal type, zeolite of ferrierite type, zeolite of mordenite type, and zeolite of ZSM-5 type) or a natural zeolite (such as zeolite of mordenite type and zeolite of clinoptilolite type), as shown in the following Examples. They are exemplary but not limitative.

According to the present invention, the catalyst is used in the presence of organic compounds as a reducing agent. The organic compounds include hydrocarbons such as methane, ethane, propane, butane and fuel oil as well as alcohols, ketones, and ethers. In other words, the method of the present invention permits a much wider selection of reducing agent than the conventional selective reduction method which resorts to ammonia as the reducing agent.

The impregnation of metallic elements in the zeolite may be accomplished by stirring the hydrogenated zeolite (prepared as mentioned above) in an aqueous solution of salts of desired metallic elements followed by separating from the solution, drying and calcining the treated zeolite (This method will be referred to as the first impregnation method.) Alternatively, the impregnation may be accomplished by contacting the zeolite with an aqueous solution of salts of desired metallic elements and then with water containing ammonium ions and finally heating the treated zeolite for volatilizing ammonia. (This method will be referred to as the second impregnation method.) The second method may be performed by reversing the order of contacting. (This method will be referred to as the third impregnation method.)

In Examples explained later, experiments were carried out using synthetic zeolites of TSM series produced

by Toso Co., Ltd., which include zeolites of Y type, L type, offretite-erionite mixed crystal type, ferrierite type, mordenite type, and ZSM-5 type. These zeolites were hydrogenated by dipping in 4N hydrochloric acid at 100 DEG C. for 4 hours and then thoroughly rinsing and drying. Experiments were also carried out using natural zeolites, which include mordenite-containing tuff (from Akita Prefecture) and clinoptilolite-containing tuff (from Fukushima Prefecture). The natural zeolites were hydrogenated by washing repeatedly with heated hydrochloric acid (2 mol/L) for 40 hours.

The catalytic activity of the hydrogenated zeolites, with or without metallic elements supported thereon, were tested in the following manner. The powder of the hydrogenated zeolite was molded under pressure, then crashed and sieved to collect particles with diameters between 10-20 mesh. The sample (5 cm³) was filled in a stainless steel reactor tube 10 mm in inside diameter. Through this reactor tube was passed a simulated exhaust gas composed of 0.15 vol% NO, 10 vol% oxygen, and 7.3 vol% moisture, with the balance being argon. As an organic compound as the reducing agent, propane was added into this exhaust gas in an amount equivalent to 4-5 times the concentration of NOx (in molar ratio). The concentrations of NOx in gases were measured by the chemiluminescence method. The percentage of NOx removed was calculated according to the formula below: ##EQU1## where, A=concentration of NOx in the gas discharged from the catalyst layer
B=concentration of NOx in the gas entering the catalyst layer

The invention will be more clearly understood with reference to the following Examples and Comparative Examples.

EXAMPLE 1

Removal of NOx by hydrogenated zeolite catalysts

Experiments on the removal of NOx by a variety of hydrogenated zeolite catalysts were carried out. The results are shown in Table 1. In these experiments, the temperature of the reactor was kept at 400 DEG C. and the flow rate of the simulated exhaust gas was 210 mL per minute (equivalent to the space velocity of 2500 hr⁻¹). It is noted from Table 1 that the percentages of NOx removed are zero in the cases of zeolites having silica/alumina ratios lower than 10 and that the percentages of NOx removed are higher than 30% in the cases of zeolites having silica/alumina ratios higher than 12. The results indicate that the hydrogenated zeolites themselves can remove NOx from the exhaust gas containing excess oxygen so long as the zeolites have silica/alumina ratios higher than about 10 and the exhaust gas is incorporated with an organic compound as the reducing agent.

TABLE 1

Silica/alumina Percentage of Type of zeolite ratio NOx removed (%)
Y type 5.9 0
L type 6.2 0
Offretite-erionite 7.4 0
mixed crystal type
Mordenite type 10.2 1
Ferrierite type 12.2 34.0
Mordenite type 14.9 35.0
Ferrierite type 20.5 41.0
ZSM-5 type 40.0 40.0

EXAMPLE 2

Removal of NO_x by metal-impregnated hydrogenated zeolite catalysts

Experiments were carried out in the same manner as in Example 1 using a variety of catalysts impregnated with one or more metals selected from among nickel, copper, manganese, chromium, cobalt, zinc, iron, and vanadium. The results are shown in Table 2. It is noted from Table 2 that hydrogenated zeolites become more active when they are impregnated with metallic elements. The percentage of NO_x removed is higher than 20% even when the silica/alumina ratio is lower than 10 (except in the case of zinc catalyst). And the percentage of NO_x removed is higher than 60% if the silica/alumina ratio is higher than 10 (except in the case of zinc catalyst). Thus the percentage of NO_x removed is greatly increased when hydrogenated-zeolites are impregnated with metallic elements.

TABLE 2

Metallic Silica/ Percentage Conversion
element Kind of alumina of NO _x
into nitrogen
supported
carrier* ratio removed (%)
gas (%)
Copper A 5.9 100 100
B 12.2 100 99
C 14.9 100 100
D 40.0 100 100
Vanadium
A 5.9 33.6 100
B 12.2 86.8 100
C 14.9 84.5 99
D 40.0 86.2 99
Chromium
A 5.9 29.7 97
B 12.2 46.7 99
C 14.9 42.7 99
D 40.0 49.3 100
Manganese
A 5.9 81.1 100
B 12.2 97.9 100
C 14.9 89.2 99
D 40.0 99.1 100
Cobalt A 5.9 20.7 98
B 12.2 77.3 100
C 14.9 88.4 97
D 40.0 89.8 99
Nickel A 5.9 66.2 100
B 12.2 99.8 100
C 14.9 87.8 100
D 40.0 99.9 100
Zinc A 5.9 13.7 97
B 12.2 23.5 96
C 14.9 22.3 95
D 40.0 23.0 98
Iron A 5.9 25.4 92
B 12.2 66.5 100
C 14.9 65.7 100
D 40.0 68.3 97

*A: Y type, B: ferrierite type, C: mordenite type, D: ZSM5 type

EXAMPLE 3

Effect of space velocity on the removal of NO_x by metal-impregnated zeolite catalysts

Similar experiments to those in Example 2 were carried out using copper catalysts or copper-nickel catalysts to examine the effect of space velocity on the removal of NO_x. No water vapor was added to the simulated exhaust gas in these experiments. The results are shown in Table 3. It is noted that catalysts on zeolites having a silica/alumina ratio lower than 10 achieve the percentage of NO_x removed higher than 50% even when the space velocity is increased eight-fold (up to 20,000 hr@-1). In the case of catalysts on zeolites having silica/alumina ratios higher than 10, the percentage of NO_x removed is higher than 90% at the same space velocity

TABLE 3

Zeolite Percentage Conversion Metallic (silica/ Space of NO _x into element alumina velocity removed nitrogen supported ratio) (hr@-1) (%) gas (%)
Copper Type Y 5000 100 100 (5.9) 10000 96.2 100 15000 64.5 99 20000 51.6 98
Ferrierite 5000 100 100 type 10000 100 100 (12.2) 15000 100 100 20000 96.4 99
Mordenite 5000 100 100 type 10000 100 100 (14.9) 15000 98.6 97 20000 87.3 98
ZSM-5 5000 100 100 type 10000 100 100 (40.0) 15000 100 98 20000 97.6 99
Copper- Type Y 5000 100 96 nickel (5.9) 10000 100 100 15000 92.5 100 20000 63.2 98
Ferrierite 5000 100 100 type 10000 100 97 (12.2) 15000 100 99 20000 93.2 100
Mordenite 5000 100 100 type 10000 100 96 (14.9) 15000 100 100 20000 98.8 99
ZSM-5 5000 100 100 type 10000 100 100 (40.0) 15000 100 95 20000 99.1 97

EXAMPLE 4

Identification of reaction products

The exhaust gas treated by the present catalysts may contain nitrous oxide (N_2O) and nitric acid as well as nitrogen gas. To identify these compounds, the treated exhaust gas was analyzed. Since the simulated exhaust gas does not contain nitrogen gas, it is possible to calculate the conversion of NO_x into nitrogen from the amount of nitrogen produced. The determination of nitrogen and nitrous oxide was carried out by gas chromatography. The determination of nitric acid was carried out by alkali titration of the condensate recovered from the treated gas by cooling by ice. It was found that the amounts of nitrous oxide and nitric acid were smaller than the limit of detection.

In Tables 2 and 3, the conversion of NO_x into nitrogen gas is expressed in percentage calculated under the assumption that 2 mol of NO_x removed gives rise to 1 mol of nitrogen gas. It is noted that the metal-impregnated catalysts of the present invention convert NO_x into nitrogen gas almost completely.

EXAMPLE 5

Denitration by natural mordenite

Experiments of denitration were carried out using metal-impregnated catalysts prepared from natural mordenite (from Akita Prefecture) treated by the direct hydrogenation. The metal impregnation was accomplished by the above-mentioned first method. The direct hydrogenation was accomplished by washing natural mordenite repeatedly with 2N hydrochloric acid at 100 DEG C. for 40 hours. The metals impregnated on the catalysts were prepared mostly from nitrates (except palladium chloride, rhodium chloride, chloroplatinic acid, ammonium metavanadate, and ammonium molybdate). For metal impregnation, the catalyst was dipped in the aqueous solution (1 mol/L) of a volume three times as much as that of the catalyst, at 90 DEG C. for 2 hours.

The conditions of experiments were as follows. The catalyst bed was prepared by filling a column, 2 cm in inside diameter and 16 cm high, with catalyst particles, 10-20 mesh in size. The simulated exhaust gas was passed at a flow rate of 1 liter per minute. The simulated exhaust gas was composed of N₂ (80 vol%), O₂ (10 vol%), CO₂ (10 vol%), NO (0.17 vol%), and moisture produced by injecting 4 g of water per hour into the gas. The gas was preheated to the reaction temperature and incorporated with an organic compound as the reducing agent.

The results are shown in Table 4. Propane used as the reducing agent is a fuel-grade commercial product composed of 92% of propane, 8% of ethane, and 0.1% of isobutane. Gas oil is a commercial product for diesel cars. Other organic compounds are commercial reagents.

TABLE 4

Reaction	Name of	Amount	Ratio of	Element tempera-	reducing	added Denitra-	supported	ture (DEGC.)	agent (mg/min)	tion (%)	Remarks
None	430	None	0.8								
None	430	Propane									
3.8	55										
None	430	Gas oil									
4.3	47										
None	350	Gas oil									
4.3	45										
None	430	Gas oil									

4.3 47
None 500 Gas oil
4.3 41
None 430 Ethanol
6.0 57
None 430 Ethylene
4.0 50
None 430 Acetone
5.0 47
None 430 n-C10 H22
7.0 55
None 430 Ether 5.0 47
None 430 Isobutane
4.0 50
Copper 400 None 0 8
Copper 500 None 0 6
Copper 600 None 0 3
Copper 400 Propane
3.8 34
Copper 500 Propane
3.8 36
Copper 500 Propane
3.8 36 O₂ = 5%
Copper 600 Propane
3.8 38
Copper 600 Propane
8.0 61
Copper 600 Propane
11.4 74
Copper 500 Ethanol
6.0 40
Copper 500 n-C10 H22
7.0 50
Copper 500 Ether 5.0 45
Copper 500 Acetone
5.0 48
Chromium
430 None 0 15
Chromium
430 Propane
3.8 52
Nickel 430 None 0 63
Nickel 430 Propane
3.8 83
Nickel 430 Gas oil
4.3 50
Nickel 430 n-C10 H22
5.0 75
Nickel 430 Ethanol
5.0 60
Iron 430 None 0 7
Iron 430 Propane
3.8 62
Cobalt 430 None 0 27
Cobalt 430 Propane
3.8 68
Cobalt 430 Gas oil
4.3 50
Cobalt 430 Ethanol
5.0 70

Palladium
400 None 0 18
Palladium
500 None 0 18
Palladium
430 None 0 10
Palladium
430 Propane
3.8 55
Palladium
430 Propane
3.8 67
Manganese
430 None 0 10
Manganese
430 Propane
3.8 75
Manganese
430 Propane
3.8 78
Manganese
430 Gas oil
4.3 50
Manganese
430 n-C6 H14
6.0 65
Manganese
430 n-C10 H22
7.0 60
Manganese
430 Ethanol
6.0 58
Manganese
430 Ethylene
4.0 70
Manganese
430 Acetone
5.0 65 O₂ = 5%
Manganese
430 n-Butane
4.0 70
Manganese
430 Isobutane
4.0 70
Molybdenum
430 None 0 10
Molybdenum
430 Propane
3.8 51
Molybdenum
430 Gas oil
4.3 45
Rhodium 430 None 0 15
Rhodium 430 Propane
3.8 51
Rhodium 430 Gas oil
4.3 40
Platinum
430 None 0 10
Platinum

430 Propane
3.8 55
Platinum
430 Gas oil
4.3 46
V-Mn binary
300 None 0 15
V-Mn binary
400 None 0 11
V-Mn binary
300 Propane
3.8 27
V-Mn binary
400 Propane
3.8 89
V-Mn binary
400 Propane
7.3 95
V-Mn binary
500 Propane
3.8 85
V-Mn binary
400 Gas oil
4.3 60
Cr-Mn binary
430 Propane
3.8 44
V-Ni binary
430 None 0 9
V-Ni binary
430 Propane
3.8 62
Cr-Ni binary
430 None 0 16
Cr-Ni binary
430 Propane
3.8 46
Cr-Ni binary
430 Gas oil
4.3 33
Cr-Cu binary
300 None 0 0
Cr-Cu binary
400 None 0 16
Cr-Cu binary
250 Propane
3.8 4
Cr-Cu binary
300 Propane
3.8 10
Cr-Cu binary
430 Propane
3.8 27
Cr-Cu binary
300 Gas oil
4.3 27
Cr-Cu binary
320 Gas oil
4.3 36
Cr-Cu binary

430 Gas oil
4.3 27
Cr-V binary
300 None 0 7
Cr-V binary
330 None 0 8
Cr-V binary
360 None 0 25
Cr-V binary
300 Propane
3.8 36
Cr-V binary
330 Propane
3.8 61
Cr-V binary
360 Propane
3.8 63
Cr-V binary
300 Gas oil
4.3 27
Cr-V binary
360 Gas oil
4.3 22
Cr-Fe binary
300 None 0 7
Cr-Fe binary
330 None 0 14
Cr-Fe binary
360 None 0 6
Cr-Fe binary
380 None 0 6
Cr-Fe binary
430 None 0 4
Cr-Fe binary
300 Propane
3.8 58
Cr-Fe binary
330 Propane
3.8 78
Cr-Fe binary
380 Propane
3.8 58
Cr-Fe binary
430 Propane
3.8 46
Cr-Fe binary
300 Gas oil
4.3 52
Cr-Fe binary
330 Gas oil
4.3 55
Cr-Fe binary
380 Gas oil
4.3 33
Cr-Fe binary
430 n-C10 H22
5.0 78

EXAMPLE 6

Denitration by natural clinoptilolite

Similar experiments as in Example 5 were carried out except that the catalysts were prepared from clinoptilolite (from Fukushima Prefecture). Results are shown in Table 5.

TABLE 5

Reaction Name of Amount Ratio of Element tempera- reducing added Denitra- supported ture (DEGC.) agent (mg/min) tion (%) Remarks
None 430 Propane 3.8 40
None 430 Gas oil 4.3 40
None 430 n-C10 H22 7.0 50
None 430 Ethanol 6.0 54
None 430 Ether 5.0 43
None 430 Isobutane 4.0 40
Iron 430 None 0 10
Iron 430 Propane 3.8 40
Iron 430 Gas oil 4.3 30
Chromium 430 None 0 10
Chromium 430 Propane 3.8 44
Chromium 350 Gas oil 4.3 43
Chromium 430 Gas oil 4.3 50
Chromium 520 Gas oil 4.3 40
Manganese 430 None 0 8
Manganese 430 Propane 3.8 67
Manganese 430 Ethanol 6.0 60
Manganese 430 Gas oil

4.3 45
 Manganese
 430 n-C10 H22
 7.0 50
 Nickel 430 None 0 51
 Nickel 430 Propane
 3.8 70
 Nickel 430 Gas oil
 4.3 45
 Cr-Fe binary
 430 None 0 10
 Cr-Fe binary
 330 Propane
 3.8 65
 Cr-Fe binary
 430 Propane
 3.8 40
 Cr-Fe binary
 330 Gas oil
 4.3 47
 Cr-Fe binary
 380 Gas oil
 4.3 40

EXAMPLE 7

Denitration by catalysts hydrogenated by the indirect method

In this example the same raw material and impregnation method as in Example 5 were used except that the hydrogenation was carried out by the indirect method in the following manner. Natural mordenite rocks were crushed, and the resulting powder was dipped in an aqueous solution of ammonium chloride (2 mol/L) at 90 DEG C. for 2 hours. The powder was then heated to 600 DEG C. to volatilize ammonia. The results are shown in Table 6.

EXAMPLE 8

Effect of the second impregnation method

The catalyst was prepared from the natural mordenite as in Example 5. The zeolite was caused to support a desired metallic element and then hydrogenated by the ammonium ion exchange according to the above-mentioned second impregnation method. The results are shown in Table 6.

EXAMPLE 9

Effect of the third impregnation method

The catalyst was prepared from the same zeolite as in Example 5. The zeolite was caused to support a desired metallic element according to the above-mentioned third impregnation method. The results are shown in Table 6.

TABLE 6

Reaction Name of	
Amount Ratio of	
Example	
Element tempera- reducing	
added Denitra-	
No. supported ure (DEGC.)	
agent (mg/min)	
tion (%)	

7 None 430 None 0 0
 7 None 430 Propane
 3.8 59
 7 None 430 Gas oil
 4.3 32
 7 Manganese 430 None 0 3
 7 Manganese 430 Propane
 3.8 69
 7 Manganese 430 Gas oil
 4.3 55
 7 Iron 430 Propane
 3.8 40
 7 Copper 430 Propane
 3.8 35
 8 Manganese 430 None 0 10
 8 Manganese 430 Propane
 3.8 67
 8 Manganese 430 Gas oil
 4.3 35
 9 Manganese 430 Propane
 3.8 86
 9 Nickel 430 None 0 5
 9 Nickel 430 Propane
 3.8 59

COMPARATIVE EXAMPLE 1**Removal of NOx by unhydrogenated zeolites**

Experiments were carried out under the same conditions as in Example 1 except that the zeolite was not hydrogenated. The results are shown in Table 7. It is noted that only very little NOx was removed.

COMPARATIVE EXAMPLE 2**Removal of NOx by hydrogenated zeolite catalysts in the absence of organic compounds**

Experiments were carried out under the same conditions as in Example 1 except that the organic compound as the reducing agent was not added. The results are shown in Table 7. It is noted that only very little NOx was removed.

COMPARATIVE EXAMPLE 3**Removal of NOx by metal-impregnated hydrogenated zeolite catalysts in the absence of organic compounds**

Experiments were carried out using metal-impregnated catalysts under the same conditions as in Example 2 except that no organic compound as the reducing agent was added. The results are shown in Table 7. It is noted that the percentage of NOx removed was less than 10%.

TABLE 7

Silica/ Removal of NOx (%)
alumina Comparative
Comparative
Comparative
Zeolite
ratio Example 1 Example 2 Example 3

A 5.9 0 0 3

B 12.2 1 7 0
C 14.9 0 0 4
D 40.0 2 5 9

Designation of zeolite:

- A: Zeolite of Y type
 - B: Zeolite of ferrierite type
 - C: Zeolite of mordenite type
 - D: Zeolite of ZSM-5 type
-

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Claims

What is claimed is:

1. A method for removing nitrogen oxides from exhaust gas containing oxygen and moisture, comprising the step of bringing the exhaust gas into contact with a hydrogenated zeolite catalyst selected from the group consisting of hydrogenated synthetic zeolites, hydrogenated natural zeolites, hydrogenated synthetic zeolites impregnated with one or more metals selected from the group consisting of copper, zinc, vanadium, chromium, manganese, iron, cobalt, nickel, rhodium, palladium, platinum and molybdenum, and hydrogenated natural zeolites impregnated with one or more metals selected from the group consisting of copper, zinc, vanadium, chromium, manganese, iron, cobalt, nickel, rhodium, palladium, platinum, and molybdenum, in the presence of organic compounds as a reducing agent selected from the group consisting of hydrocarbons, alcohols, ketones, or ether, at a temperature sufficient to cause reaction between said hydrogenated zeolite catalyst and said nitrogen oxides.
2. A method for removing nitrogen oxides from exhaust gas as claimed in claim 1, wherein the zeolite catalyst is a zeolite having a silica/alumina ratio of 5 or above.
3. A method for removing nitrogen oxides from exhaust gas as claimed in claim 1 or claim 2, wherein the hydrogenated zeolite catalyst is any one of zeolite of Y type, zeolite of L type, zeolite of offretite-erionite mixed crystal type, zeolite of ferrierite type, zeolite of mordenite type, zeolite of clinoptilolite type, and zeolite of ZSM-5 type.

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